

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028389**Date Inspected:** 13-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR**CWI Name:** David Speakman**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge A Restraint Brackets**Summary of Items Observed:**

This Quality Assurance Inspector (QAI), Dan Chang, observed Quality Control Inspector (QCI), Tony Corsaletti, of American Bridge Manufacturing (ABM) monitor the in process welding of Hinge A Restraint Brackets of CCO 120S1. QCI was observed to monitor welding amperage and voltage with an Amprobe Model ACDC-100 during the welding process. The welding process was performed by Mike Catlett utilizing Flux Cored Arc Welding (FACW) with E71T-1 1/16" diameter electrode for the partial penetration and fillet welds. QCI noted that the Welding Procedure Specifications (WPS) being used are ABM-SAS-07 and ABM-SAS-08 with amperage of 300, voltage of 27, and travel speed being 18 inches per minute (ipm). The joint was preheated to 150 °F by the welder prior to the start of the welding operation which was verified by QCI using an Extech mini-infrared thermometer Model 42500. This QAI performed random observations of the welding process during this work shift and noted that Mike Catlett was welding restraint bracket piece-mark # X01A-3, X01A-5, and X01A-8. At the time of the observation the in process welding appeared to be within general compliance of the contract documents.

This QAI also performed observation on Hinge K Soffit Opening of CCO 241, please refer to report 04-0120F4_TL6034_B344_CCO 241-9-13-12 for more information.

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Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	X010A-3	ABS-SAS-07,08	David Speakman	300	27	18	150 F	Welding operation by Mike Catlett
2	X01A-5	ABS-SAS-07,08	David Speakman	300	27	18	150 F	Welding operation by Mike Catlett
3	X01A-8	ABS-SAS-07,08	David Speakman	300	27	18	150 F	Welding operation by Mike Catlett

Summary of Conversations:

Basic communication between the QA and QC inspectors regarding the schedule of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas, 916-674-6027, who represents the Office of Structural Materials for your project.

Inspected By: Chang,Dan

Quality Assurance Inspector

Reviewed By: Foerder,Mike

QA Reviewer